

Page 1

Revision ID:	D4114-2  Door Doubler, RF	4		Accept				s	etup Star Stoj	1 (00)(10)	
	12/7/2010 S	tart Qty: 4.00 Req'd Qty: 4.00	1847  614   184   1847  614   184		Cust Item I Customer:	D:				1 (1864)(1 <u>8</u> 1 (	
Approvals:	Process Plan: QC:	H_	Date:/ <i>()-/2-</i> 7	Tooling: SPC (Y/N):		ate:		R	un Star Sto		
Sequence ID/ Work Center II		peration escription	· · · · · ·	Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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D4114	Α										
				0.00				<b>6</b> 10		,	
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FLOW CNC Waterje	et	1-Cut as p Dwg Rev Prog Rev	- <del></del>					-	·	(ì	É
1		2-Deburr	if necessary								
110 Herier (1881) (1881) (1881)	. Q	C2- Inspect parts off	machine FAI/FAIB	0.00							
QÇ Quality Control		Memo		0.00				<u> (B</u> (C	<u>, - () - (</u>	<u>ب</u>	

Dart Aerospace I
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W/O:			WO	RK ORDER CHANG	ES				<del>,</del>
DATE	STEP	PRO	OCEDURE CHAP	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	Part No: PAR #:		Fault Cate	gory:	_ NCR: Yes	No [	DQA:	Date: _	
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NCR:			WORK ORDE	R NON-CONFORM	ANCE (NC	R)			
DATE	STEP	Description of NC			ion B		rification	Approval	Approval
DAIL	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat		Section C	Chief Eng	QC Inspector
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		. *							
	1								1

## Work Order ID 64499

Tuesday, December 07, 2010 8:51:57 AM



Page 2

Item ID:

D4114-2

Accept



Setup Start

Stop



**Revision ID:** 

Item Name:

Door Doubler, RH

**Start Date:** 12/7/2010 **Required Date: 12/20/2010** 

Start Qty: 4.00

Req'd Qty: 4.00



**Cust Item ID: Customer:** 

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date:

Tooling:

Date:

Run

Start Stop

QC:

Date:\_\_\_\_\_

**SPC (Y/N):** 

Date:

Sequence ID/ Work Center ID

120

Quality Control

Operation Description

QC8- Inspect parts - second check

Memo

Set Up/ **Run Hours** 

Tool ID

Accept Tool # Plan Qty Code

Reject Qty

Reject Number

Insp. Stamp

130

Small Fab

Small Fab

Memo

Memo

1- C'sink holes as per dwg

140

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

10/12/12

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W/O:			WO	RK ORDER CHANGE	S				
DATE	STEP	PRO	DCEDURE CHAP	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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DATE	CTED	Description of NC		Corrective Action Section		Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng			Section C Chi		QC Inspector
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### Work Order ID 64499

**Required Date: 12/20/2010** 

Tuesday, December 07, 2010 8:51:57 AM



Page 3

Item ID:

D4114-2

Accept

Setup Start



Revision ID:

Item Name:

Door Doubler, RH

**Start Date:** 

12/7/2010

Start Qty: 4.00

Req'd Qty: 4.00



**Cust Item ID: Customer:** 

Reference:

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QC:

Process Plan:

Date:\_\_\_\_\_

Date:

Tooling:

0.00

SPC (Y/N):

Set Up/

**Run Hours** 

Date:

Run

Start Stop

Stop



Sequence ID/ Work Center ID

150

Packaging Packaging

Operation Description

Identify as per dwg & Stock Location: 130

0.00

**Tool ID** 

Tool # Plan Code

Date:\_\_\_\_

Accept Qty

Reject Qty

Reject Number Stamp

Insp.

160 OC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

Memo

0.00

10/12/2094) MV 12/11

# Dart Aerospace Ltd

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N/O:		WORK ORDER CHANGES												
DATĖ	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector					
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NCR:			WORK ORI	DER NON-CONFORM	ANCE (NCF	R)								
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## Picklist Print

Tuesday, December 07, 2010 8:52:03 AM

Work Order ID: 64499

Parent Item: D4114-2

Parent Ite... Name: Door Doubler, RH

MAT

Start Date: 12/7/2010

Required Date: 12/20/2010

Start Qty: 4.00

Required Qty: 4.00

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IPP rev:A 10.09.24 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	124.0000	0.25	1.052632 <b>!&amp;</b> (0	D-( <b>}-</b>	16	
				Location	1	Loc	<u>Qty</u>	Loc Code				_	

<u>tion</u>	Loc Qty	Loc Code	
	124		
111323	0		
115953	124		115853

Dart Ae	rospace	Ltd							
W/O:		the state of the s	WO	RK ORDER CHANGE	S				
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Resolution:			Disposition	:	QA: N/C Closed: Date:				
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		Description of NC		Corrective Action Section		Verification			Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sect	tion C	Approval Chief Eng	QC Inspector

DART AEROSPACE LTD	Work Order:	64499 '
Description: DOOR Doubles RH.	Part Number:	D4114-7
Inspection Dwg: D+(1)\(\frac{1}{2}\), Rev: A		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	X	Prototype
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		Date: 1017/6	Date:	
Date.	10-17-46	0112118		

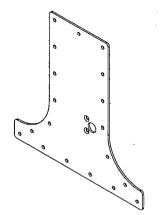
Г		Deta	Change	Revised by	Approved
	Rev	Date	Change	KJ/JLM	
	Α		New Issue	1070EW	<u></u>

SHOP COPY RETURN TO ENGINEERING **UNCONTROLLED COPY** 

SUBJECT TO AMENDMENT WITHOUT NOTICE

WORK ORDER NO. 449

D4114-1 DOOR DOUBLER, LH



D4114-2 DOOR DOUBLER, RH

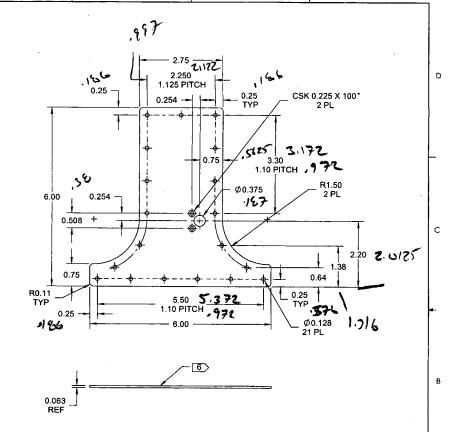
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REV.			DESCRIPTION	BY	DATE			
DESIG	N .	JPH	DART AERO	IID				
DRAW	N .	JPH		HAWKESBURY, ONTARIO, CANAD.				
CHECK	ŒD	13	DRAWING NO.		REV. A			
MFG. APPR.		TA C	D4114		SHEET 1 OF 2			
APPRO	APPROVED A		TITLE		SCALE			
DE APPR.			DOOR DOUBLER N					
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## **Dart Aerospace Ltd**

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W/O:			WC	ES					
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Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes I	No DQA:	Date: _		
			Dispositio	Disposition: Q		QA: N/C Closed: Date: _			
NCR:	*	,	WORK ORD	ER NON-CONFORM	ANCE (NCR	)			
DATE	STEP	Description of NC Section A	Corrective Action Section			Verificatio		Approval	
DAIL	SIEP		Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector	
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2.75 2.250 1.125 PITCH 0.25 CSK 0.225 X 100° - 0.254 2 PL 3.30 1.10 PITCH Ø0.375 R1.50 0.254 6.00 2 PL + 0.508 2.20 1.38 0.75 0.64 0.25 R0.11 5.50 TYP TYP 1.10 PITCH 0.25 Ø0.128 21 PL 6.00 0.063

**D4114-1 DOOR DOUBLER, LH** 



**D4114-2 DOOR DOUBLER, RH** 

DESIGN DART AEROSPACE LTD DRAWN JPH HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. A MFG. APPR. D4114 SHEET 2 OF 2 TITLE APPROVED SCALE DOOR DOUBLER DE APPR. NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND COMPETENTIAL AND IS SUPPLED ON THE EXPRESS CONDITIONS TO BE ANY PURPOSE OR COPYRIGHT OR COMPANIES TO ANY OTHER PROPERTY OF COMPANIES TO THE EXPRESS CONDITIONS OF COMPANIES TO THE EXPRESS CONDITIONS OF COMPANIES TO THE EXPRESS CONDITIONS OF COMPANIES TO THE EXPRESS CONDITIONS OF COMPANIES TO THE EXPRESS CONDITIONS OF COMPANIES TO THE EXPRESS CONDITIONS OF COMPANIES TO THE EXPRESS OF CO DATE 10.07.20

W64499

NOTES: 1) MATERIAL -1 & -2: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.063 THK PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 PER DART SPEC M304S16GA OR M303S16GA

PER DART SPEC M304S16GA OR M303S16GA
2) FINISH: NONE.
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
4) UNITS: INCHES UNLESS OTHERWISE NOTED.
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENT P/N D4114-X & B/N PER QSI 044 6.1
7) WEIGHT -1 & -2: 0.35 lbs

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7

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## **Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Part No	:	PAR #:	Fault Cate	Fault Category: I			NCR: Yes No DQA: Date:				
Resolution:			Disposition: QA:			A: N/C Closed: Date:					
NCR:			WORK ORDE	ER NON-CONFORM	ANCE (NCI	R)					
DATE	STEP	Description of NC Section A	Corrective Action Section B			Sign & Verification		Approval Chief Eng	Approval		
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